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RBE703A95-0505-00
Job Sheet 181135



5827

Part No: RBE703A95-0505-00

Job Qty: 4 ea

Part Name: Hose, Main Gear Box Tail Gear Box Draining



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/22/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE703A95-0505-00 Rev 9 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	4 pcs	8/20/18	8/20/18	0.00	4.00	Small Fab-3		MCC DAS
120	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC5		OCT 12 2018 68
130	Packaging	4 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-1		7/10 9-89
140	QC21-SA	4 Ea	8/20/18	8/20/18	0.00	0.00	QC21		DAS OCT 15 2018 21 9-89 GA076

Part Op 110 - Assemble and package as per DWG.
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	1.2800 ft (.32 ea)	90-Start up Operation	3016490
2044T67	Cap Ø1.09	2 Ea (2 ea)	90-Start up Operation	6x 3093307 18x50 93308
51495K116	COUPLING 1/2" NCKL PLTD BRASS	1 Ea (1 ea)	90-Start up Operation	5x 3053241 2x3113 238
9263K173	O-Ring	12 Ea (1 ea)	90-Start up Operation	3093347
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	28 ft (7 ea)	90-Start up Operation	3096753
PAD210	Foam Ø1 X 1	.0280 sf (.007 ea)	90-Start up Operation	304250
RBE703A95-0505-00-1	Quill	12 Ea (1 ea)	90-Start up Operation	8x 3078893 7x304 0167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2044T47	1	29	0
	2044T67	8	142	0
	51495K116	4	63	0
	9263K173	4	55	0
	K010-0608	28	153	0
	PAD210	0	13	0
	RBE703A95-0505-00-1	4	17	0

Part Specifications

Specifications could not be found.

Plex 7/23/18 8:07 AM dart.logan.david

DART
AEROSPACE

Container No: S116692

Part: FBE703A95-0505-00

Job No: 181135

Serial No/Batch: S116692

Revision: 9

Inspector:

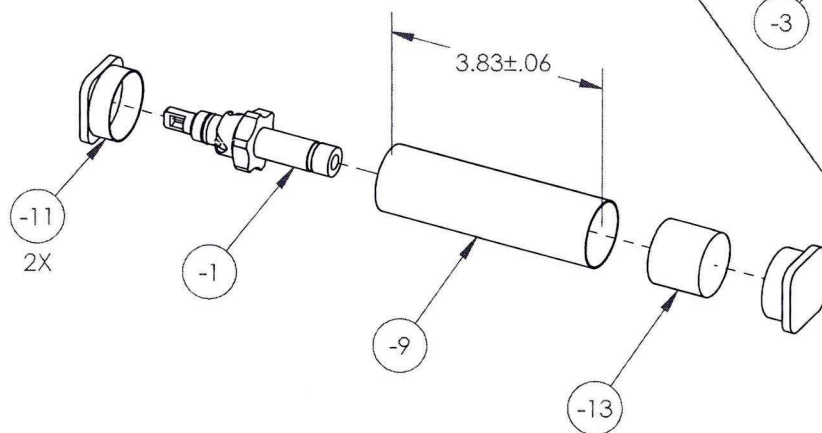
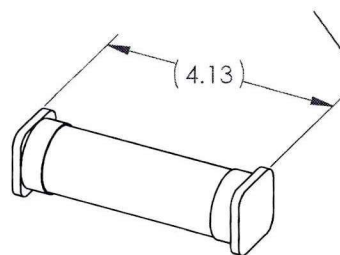
Exp Date:

Instructions:

Date: 10/08/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED O-RING SIZE FROM Ø 14.4mm OD x 2.4mm CROSS SECTION. ALSO ADDED NOTES. CHD SLOTS FROM 90° Ø .131 AND ID FROM .230	5/28/2009	WP	RW
1A		DELETED 49° REF. DIM. FOR -1 PER G.E.	12/16/2010	RJC	RW
2		CH'D ENGAGEMENT SLOT ANGLE FROM 60° TO 90° PER G.E.	3/7/2011	RJC	
3		MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, TUBE, AND CAPS, DELETED HOSE CLAMP AND LABEL. CH'D HOSE FROM Ø 5/8 OD TO Ø 1/2 OD	7/30/2012	JAG	
4		CH'D 8X R.155 & 8X .121 TO 6X R.375 & 6X .106	4/17/2013	CFS	GE
5		CH'D T/N WAS RBEA95-0505-00-1 IS RBE703A95-0505-00-1. -1 CH'D DIM WAS Ø.125 ± .079 IS Ø.125 +.005/- .000 ± .079. CH'D DIM WAS 6X .106 IS 6X .111. CH'D DIM WAS 6X R.375 IS 6X R.38.	6/19/2013	BIM	RW
7A		CH'D TOOL NAME WAS T/R GEAR BOX DRAIN TOOL IS TGB DRAIN TUBE.	11/7/2013	RJC	RW
7B		-1 CH'D DIMS WAS 2X .039 X 45° IS 2X .40 X 45°, WAS .020 IS .02, WAS 2X 30° IS 30°, WAS 6X .11 IS 6X R.38 EQUALLY SPACED ON Ø1.60 B.C., WAS Ø.250 IS Ø.25 THRU ± 2.97 MAX. ADDED NOTES WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA", WAS .500 IS .500 NO ENGRAVING. DELETED DIMS .095, .244. -9 CH'D DIM WAS 3.93 IS 3.83. -13 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD	RW
7C		-5 CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC	DW
8	15-0107	-13 CH'D B/O INFO WAS Ø1 X 1 IS Ø1.09 X 1.	5/19/2015	RJC	JAG
9	16-0257	UPDATED TO NEW STANDARDS. -1 CH'D DIM WAS Ø.25 THRU ± 2.97 MAX IS Ø.25 ± 2.97 MAX.	12/5/2016	SM	JAG

NOTES:
ALTERNATE REFERENCE No's ARE E-350-1 AND 703A95-0505-00. THIS IS ALSO THE OLD STYLE MGB PLUG TOOL.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1-1/8 X 3-1/8	2
		B/O	-3	1	O-RING	VITON	Ø13mm O.D. x 2mm WIDTH MCMaster-CARR #9263K173	1
		B/O	-5	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 7ft KUJI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-9	1	TUBE	POLYETHYLENE	Ø1.09 MCMaster-CARR #2044T47	1
		B/O	-11	2	CAP	VINYL	Ø1.09 MCMaster-CARR #2044T67	1
		B/O	-13	1	FOAM	POLYESTER/POLYURETHANE	Ø1.09 X 1 NEW PIG CORP. #PAD210	1

DART AEROSPACE	
TITLE TGB DRAIN TUBE	
DWG NO. RBE703A95-0505-00	REV 9
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS-350
SCALE 1:3	DATE 7/30/2012
SHEET 1 OF 2	